

Work Order ID 64625

Thursday, December 09, 2010 12:42:36 PM



SIP dec 14th

Page 1

Item ID: D350-588-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: mfDate: 10-12-09 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002.

8/10/12/03

HJ for BG 10-12-9 (2)

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/12/9 (2x) SP

120

0.00



QC- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/10/12/13

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Revision ID:

Stop

Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 2.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-588-011 Location: <u>22</u> PPP Rev: <u>22</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/12/13

22

10/12/14

mf

10-12-13

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Work Order ID: 64625

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010


Required Date: 12/14/2010

Start Qty: 2.00


Required Qty: 2.00

Comments: IPP Rev:M04.08.31 Added D2690-17 KJ/JLM


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7		Purchased	No			120	Each	132.0000	2	4			
													
Screw													

Location	Loc Qty	Loc Code
ST328	132	
113064	1	
113749	1	
114056	30	
116304	100	

AN526C832R8		Purchased	No			120	Each	76.0000	8	16			
													
Screw													

Location	Loc Qty	Loc Code
ST327	76	
114718	76	

AN526C832R9		Purchased	No			120	Each	17.0000	8	16			
													
Screw													

Location	Loc Qty	Loc Code
ST327	17	
115936	17	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 64625

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

AN960JD10 NAS1149D0363J Purchased No

120

Each

8.0000

4

8



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD8 NAS1149DN832J Purchased No

120

Each

10.0000

24

48



Washer

Location

Loc Qty

Loc Code

ST347

10

105059

10

D2143 Manufactured No

120

Each

22.0000



Hinge Bracket

Location

Loc Qty

Loc Code

ST198

22

55323

3

63595

19

D2144 Manufactured No

120

Each

28.0000



Hinge Bracket

Location

Loc Qty

Loc Code

ST198

28

55179

28

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

S
a
D2150
Packer Doubler, Hinge

Manufactured No

120 Each

18.0000

2

4



10/12/9 sf

Location

Loc Qty

Loc Code

ST007

18

55178

6

63562

12

4

S
a
D2151
Packer Doubler, Hinge

Manufactured No

120 Each

29.0000

2

4



10/12/9 sf

Location

Loc Qty

Loc Code

ST007

29

62246

29

4

S
a
D2153
Door Prop

Manufactured No

120 Each

7.0000

1

2



10/12/9 sf

Location

Loc Qty

Loc Code

ST272

7

59818

7

2

S
a
D2154
Stud Bracket

Manufactured No

120 Each

66.0000

1

2



10/12/9 sf @ 20

Location

Loc Qty

Loc Code

ST007

66

55325

1

63597

15

64312

50

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

D2237

Manufactured No

120 Each

28.0000

2

4

Striker Plate

Location

Loc Qty

Loc Code

ST010

28

62212

28

Manufactured No

120

f

506.5000

7.25

15.26316

D2461

Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

506.5000105

39782

6.5

55054

0.00001053

63880

500

Manufactured No

120

f

202.3205

7.25

15.26316

cut 1 X 87.00"

D2463

Seal

Location

Loc Qty

Loc Code

ST404

202.32053

55561

1.68

62597

200.64053

cut 1 X 87.00" - measured ml 10/12/09

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

S+2
D2583
Latch Bracket

Manufactured No

120 Each

55.0000

2



4
10/12/95

Location

Loc Qty

Loc Code

ST017

53

64080

22

64313

31

ST018

2

56527

2

4

S+2
D2585
Mounting Channel

Manufactured No

120 Each

30.0000

2



4
10/12/95

Location

Loc Qty

Loc Code

ST018

30

62676

30

Manufactured No

120 Each

25.0000

2



4
10/12/95

S+2
D2586
Door Latch

Manufactured No

120 Each

3.0000

1



4
10/12/95 (se)

S+2
D2587
Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST019

3

56555

3

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

S_{FL} D2589
Keys, Key Chain, 350 Hinge

Manufactured No

120 Each

145.0000

1

2

Location

Loc Qty

Loc Code

ST019

145

58194

145

120 Each

8.0000

1

2

S_{FL} D2690-17
Cable

Manufactured No

Location

Loc Qty

Loc Code

ST021

8

62480

8

120 Each

16.0000

1

2

S_{FL} D2857-1
Hinge Bracket

Manufactured No

Location

Loc Qty

Loc Code

ST026

16

57924

16

120 Each

25.0000

1

2

S_{FL} D2857-2
Hinge Bracket

Manufactured No

Location

Loc Qty

Loc Code

ST027

25

55020

1

57925

24

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Work Order ID: 64625

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

D2858-1~

Manufactured No

120

Each

7.0000

1

2



Hinge Bracket

Location

Loc Qty

Loc Code

ST027

7

56423

1

61522

6

D2858-2~

Manufactured No

120

Each

0.0000

1

2



Hinge Bracket

FG-778150-550-ROL

Purchased No

120

sf

1,823.150

1

2



7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

ST404

1823.15

108932

18

111166

397

113905

1408.15

1- cut 1 square ft of glass cloth

MS20426AD3-4

Purchased No

120

Each

5,864.000

12

24



RIVET

Location

Loc Qty

Loc Code

ST316

5864

104374

1864

110398

4000

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 64625

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

MS20470AD4-5

Purchased

No

120

Each

94.0000

18

36



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST309

94

114761

94

120

Each

370.0000

18

36

MS21042L08

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

370

116082

22

116188

348

120

Each

1,211.000

4

8

MS21042L3

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

1211

114784

215

115835

996

120

Each

119.0000

2

4

MS27039-08-11

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST288

19

114382

19

ST290

100

116289

100

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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/14/2010

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-15

Purchased

No

120

Each

125.0000

2

4



Screw



18/12/954 (2x)

Location

Loc Qty

Loc Code

ST292

125

114718

25

116169

100

✓

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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